



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1009-9
Job Sheet 175313



Part No: RBST1009-9

Job Qty: 10 ea

Part Name: Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 4/13/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG RBST1009 THRU 1020 Rev 7 IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	4/12/18	4/12/18	0.00	0.00	Start Up Machining-3		S.C.-L.
110	Lathe Conv	10 pcs	4/12/18	4/12/18	0.00	5.00	Lathe Conv-1		S.C.-L.
120	QC	10 pcs	4/12/18	4/12/18	0.00	0.00	QC2 Machining-4		S.C.-L.
130	Mill Conv	10 pcs	4/13/18	4/13/18	0.00	2.50	Mill Conv 1		S.C.-L.
140	QC	10 pcs	4/13/18	4/13/18	0.00	0.00	QC2 Machining-4		S.C.-L. 18-04-06
150	QC	10 pcs	4/13/18	4/13/18	0.00	0.00	QC8 Machining-4		D.A. 18-04-07
180	Outsource	10 pcs	4/13/18	4/13/18	0.00	0.00	Outsource12		T.B.-4-12
190	Packaging	10 pcs	4/13/18	4/13/18	0.00	0.00	Packaging2		AT 18-04-12
200	QC	10 pcs	4/13/18	4/13/18	0.00	0.00	QC6		38
210	Packaging	10 pcs	4/13/18	4/13/18	0.00	0.00	Packaging3-1		9-88
220	QC21-SA	10 Ea	4/13/18	4/13/18	0.00	0.00	QC21		18-04-16

Part Op 110 - 1-Machine as per DWG. 2-Debur

Descriptions: 180 - Issue P/O to Groupe Altech; PO P000549 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

APR 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98378A909	Perforator Pin .129" X 2-1/2"	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	98378A909	10	7	0



DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

Specifications could not be found.

Container No: S058965



Part: RBST1009-9

Job No: 175313

Serial No/Batch: S058965

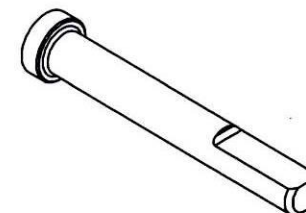
Revision: 7

Inspector:

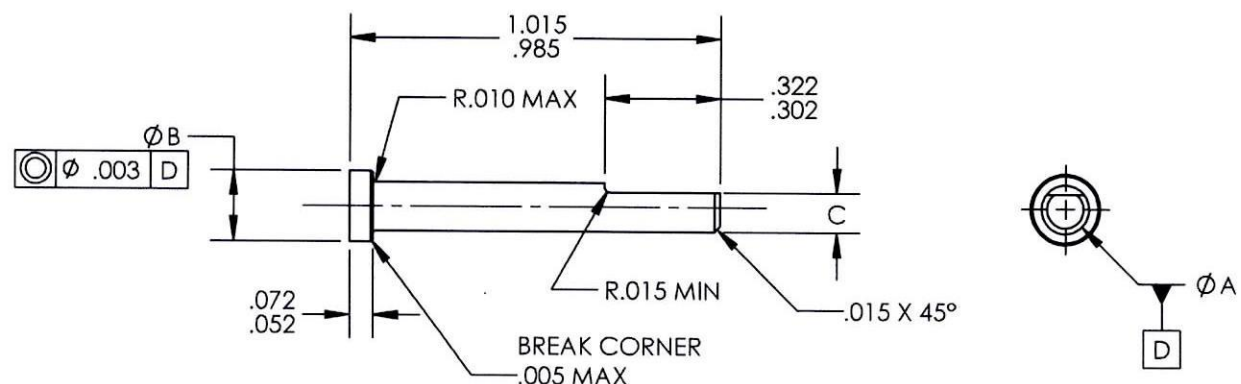
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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
7	15-0033	-9 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.			2/11/2015	DPD SM



TOOL NUMBER	ØA +.000 -.001	ØB +.005 -.002	C +.000 -.020
RBST1000	.099	.156	.074
RBST1001			
RBST1002	.129	.188	.104
RBST1003			
RBST1004			
RBST1005			
RBST1006			
RBST1007			
RBST1008			
RBST1009			
RBST1010			
RBST1011			
RBST1012			
RBST1013			
RBST1014			
RBST1015			
RBST1016			
RBST1017			
RBST1018			
RBST1019			
RBST1020			



-9

PIN

DART AEROSPACE	
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL	
DWG NO. SEE TABLE-9	REV 7
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	SEE TABLE
SCALE 2:1	DATE 1/4/2008 SHEET 6 OF 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039549

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039549
PO Date: 4/9/18
Due Date: 4/23/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172434	269T9205-5	Stop -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	4/23/18	4 pcs	0 pcs	4 pcs	\$3.42857/pcs	\$13.71
2	172907	RBE350A93-5300-00-1	Fan Extractor -Issue P/O to Groupe Altech: P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Certificate of Conformity is required	Firmed	4/23/18	2 pcs	0 pcs	2 pcs	\$87.50/pcs	\$175.00
3	173775	RBEM711V1000101-1	Cowling Plate -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	4/23/18	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	175313	RBST1009-9	Pin Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	7 pcs	0 pcs	7 pcs	\$3.42857/pcs	\$24.00
						✓ 7x	AT 18/04/12			DAE 38 9-89
5	173100	RBST2854-15	Locating Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	4 pcs	0 pcs	4 pcs	\$3.42857/pcs	\$13.71
						✓ 4x	AT 18/04/12			
6	173101	RBST2854-17	Locating Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	10 pcs	0 pcs	10 pcs	\$3.42857/pcs	\$34.29
						✓ 10x	AT 18/04/12			
7	171623	RBST2120-15	Locating Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/23/18	10 pcs	0 pcs	10 pcs	\$3.42857/pcs	\$34.29
						✓ 10x	AT 18/04/12			
Grand Total:										\$385.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retension of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 4/10/18 12:47 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(008271-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008271 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Apr-2018		Aman		039549				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	269T9205-5 Rev.	269T9205-5 BLACK OXIDE FINISH MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
4	RBST1009-9 Rev.	RBST1009-9 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0
5	RBST2854-15 Rev.	RBST2584-15 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
6	RBST2854-17 Rev.	RBST2584-17 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
7	RBST2120-15 Rev.	RBST2120-15 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.